



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9712

Job Sheet 168267**Part No: 646.9712**

Job Qty: 6 ea

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 12/1/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D2 SHEETS 1,6 IPP REV:A NEW ISSUE 13-06-20 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		11/30/17	0.00	0.00	Start Up Machining		<i>[Signature]</i>
100	Bandsaw	6 pcs		11/30/17	0.00	0.00	Bandsaw1		<i>[Signature]</i>
110	CNC Vertical Machining	6 pcs		12/1/17	0.00	7.23	HAAS 1		<i>[Signature]</i>
120	QC	6 pcs		12/1/17	0.00	0.00	QC2		<i>[Signature]</i>
130	QC	6 pcs		12/1/17	0.00	0.00	QC8		<i>[Signature]</i>
140	Outsource	6 pcs		12/1/17	0.00	0.00	Outsource4		<i>[Signature]</i>
150	Packaging	6 pcs		12/1/17	0.00	0.00	Packaging2		<i>[Signature]</i>
155	QC	6 pcs		12/1/17	0.00	0.00	QC5		<i>[Signature]</i>
180	Packaging	6 pcs		12/1/17	0.00	0.00	Packaging3		<i>[Signature]</i>
190	QC21-SA	6 Ea		12/1/17	0.00	0.00	QC21		<i>[Signature]</i>

Part Op 100 - Cut Blank at 7.425"

Descriptions: **110** - 1-Machine per folio FB199 DWG REV: FOLIO REV: 2- deburr and break all sharp edges

140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.9700 2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

180 - *IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*****

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S1.000X5.000	4	52	0	0

Part Specifications

Specifications could not be found.

Plex 11/14/17 7:31 AM dart.boucher.sylvie

TM138451 $\rightarrow$ 3.75 pied

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

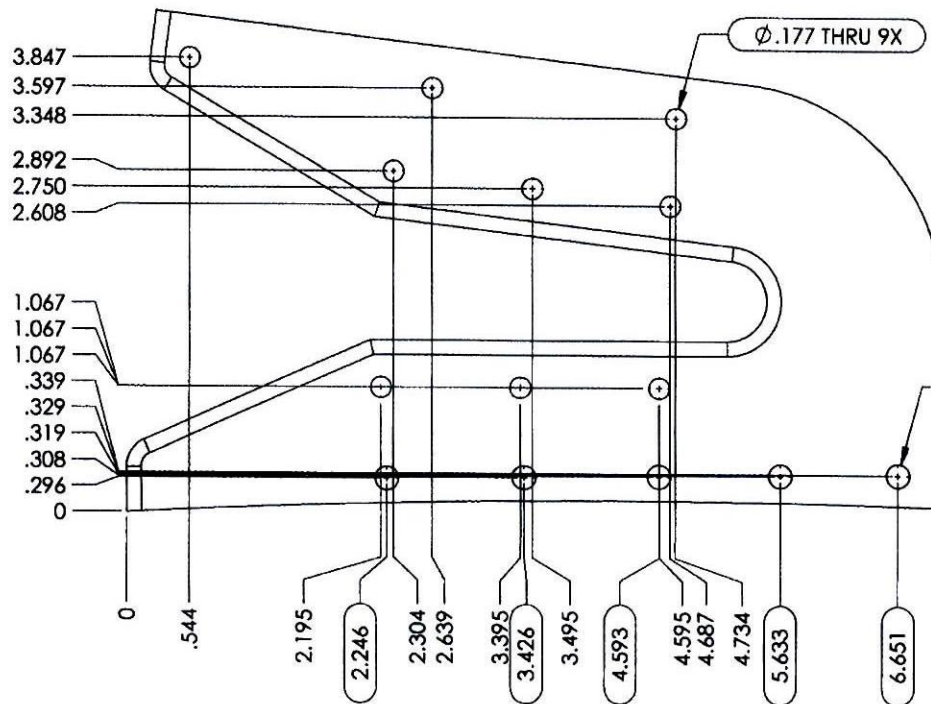
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																					
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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval																																					
Description Work Order Deviation		Disposition																																						
 S029784 Body		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																						
		Completed By																																						
		Lead hand / Supervisor Approval Verification																																						
		QC / QA Coordinator Approval																																						
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		OTHER : _____																																						

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.

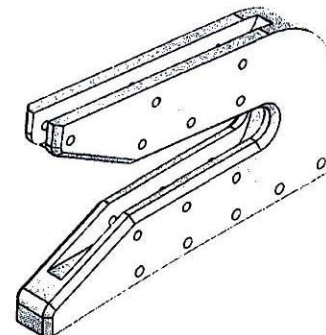
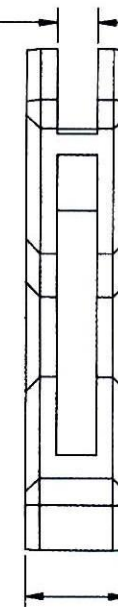
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.350



646.9712 $\triangle 9$

SHOP COPY
RETURN TO
ENGINEERING

646.9712

ORIGINAL DATE: 05-27-00		DART AEROSPACE		3030 ENTERPRISE CT., SUITE A	
DRAWN BY: R. ROSANO		CHECKED: P. BRAYO		VISTA, CA. 92081	
DRAWING APPROVAL: P. BRAYO		APICAL INDUSTRIES, INC. DBA DART AEROSPACE		(760) 724-5300	
CONTRACT NO.		CUTTER SUB ASSEMBLY			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: .01 3 PLACE DECIMALS: .005 ANGLES: 1°		SHEET: 8	CAGE CODE: 07M26	DWG. NO.: 646.9700	REV. D
SCALE: NONE		SHEET: 6 OF 7			

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 168 267

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE0.521 0.624
0.572

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

05345

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY

J. GARDINER

DATE: 03/15/16

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR.

MFG

QC

EFF.

CURRENT ORDER

REASON: REVISED NOTES

ECR:

N/A

ACTION ITEM:

1.

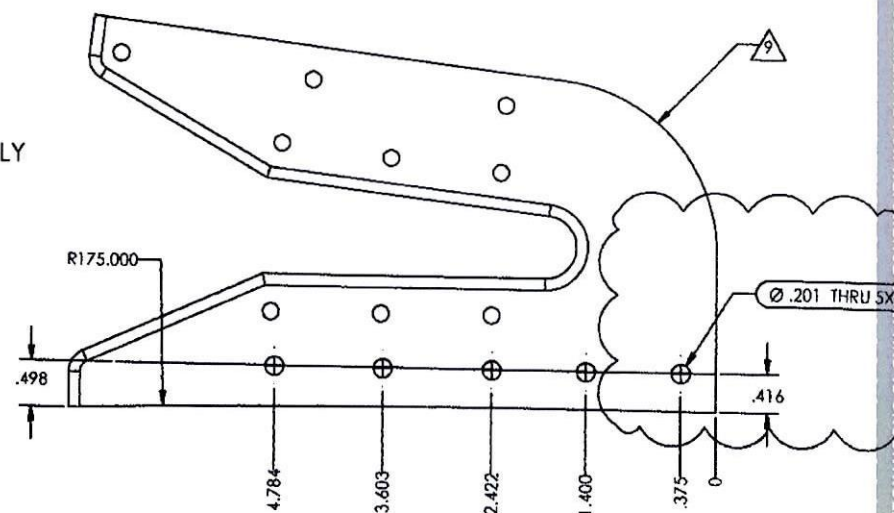
SHEET 1, ZONE A6 IS:

NOTES:

IS

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 2.1, 3.3 & 4.3.
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

SHEET 7, ZONE C5 IS:



DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038743

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038743

PO Date: 1/8/18

Due Date: 2/1/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

JAN 23 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166820	D4838-1	Upper Cutter Body, LH Issue P/O: _____ ATG, Hard Black Anodize and Prime as per Dwg D4838-1 Rev. A	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$11.61/pcs	\$116.10
2	169613	D4703-043	Lock Pin Base Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, As Per Dwg D4703	Firmed	2/1/18	4 pcs	0 pcs	4 pcs	\$4.06/pcs	\$16.24
3	168229	646.3313	Upper Guide Issue P/O to ATG : _____ Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$14.46/pcs	\$86.76
4	168224	646.3210	Support Issue P/O to ATG : _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.71/pcs	\$94.26
5	168265	646.9710	Body Issue P/O to ATG : _____ Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$15.86/pcs	\$190.32
6	165649	646.9811	Upper Deflector Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A	Firmed	2/1/18	16 pcs	0 pcs	16 pcs	\$33.96/pcs	\$543.36
7	169180	649.5010	Deflector Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 649.5000 REV. D	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$35.36/pcs	\$176.80
8	169184	649.5214	Bracket Issue P/O to ATG : _____ Hard Anodize Color Black and Prime as per Dwg 649.5200	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$10.36/pcs	\$51.80
9	169748	650.9201		Firmed	2/1/18	20 pcs	0 pcs	20 pcs	\$7.96/pcs	\$159.20

JAN 24 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038743

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	169630	D4842-1	Eyelet Bracket Assembly Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	2/1/18	8 pcs	0 pcs	8 pcs	\$13.41/pcs	\$107.28
11	169388	647.7819	Lower Cutter Deflector Outsource process- Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG D4842	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$12.61/pcs	\$126.10
12	168245	646.3715	Cross Bracket Fwd Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 647.7819	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$7.61/pcs	\$76.10
13	168267	646.9712	Strut Doubler Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.86/pcs	\$95.16
14	168268	646.9713	Body Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$8.86/pcs	\$44.30
15	169381	647.1610	Body Issue P/O to ATG : _____ Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
16	169485	647.7612	Wiper Deflector Fwd Issue P/O to ATG : _____ 1- Hard Anodize, Color Black and Prime as per Dwg, 647.1600	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
17	166816	D4823-1	Breakaway Tip Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
			Upper Cutter Deflector Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg D4823	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$12.51/pcs	\$150.12
Grand Total:									\$2,178.62	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914523

Date: 30-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: D4838-1 Upper Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22348		Rev: A PO: PO038743 Line: 1
8 ea	Part: D4842-1 Lower Cutter Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22356		Rev: B PO: PO038743 Line: 10
6 ea	Part: 646.9712 Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Job: 22359		Rev: D PO: PO038743 Line: 13
6 ea	Part: 646.3313 Upper Guide Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22350		Rev: NC PO: PO038743 Line: 3
6 ea	Part: 646.3210 Support Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22351		Rev: NC PO: PO038743 Line: 4
Made in Canada			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914523

Date: 30-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
5 ea	Part: 649.5214 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22355	Rev: A	PO: PO038743 Line: 8
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>30/1/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			